

FIG. 1

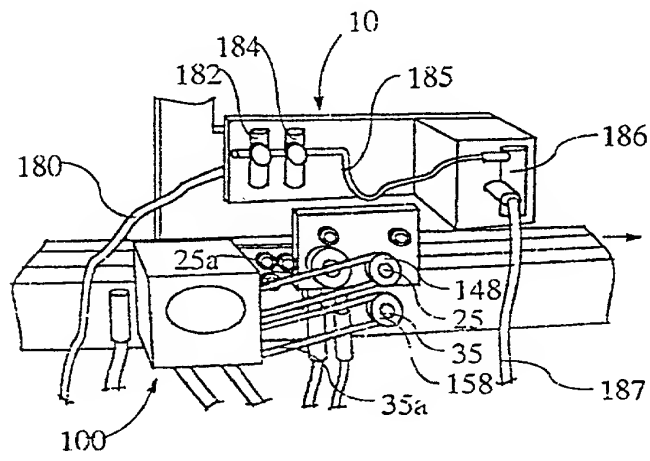


FIG. 2

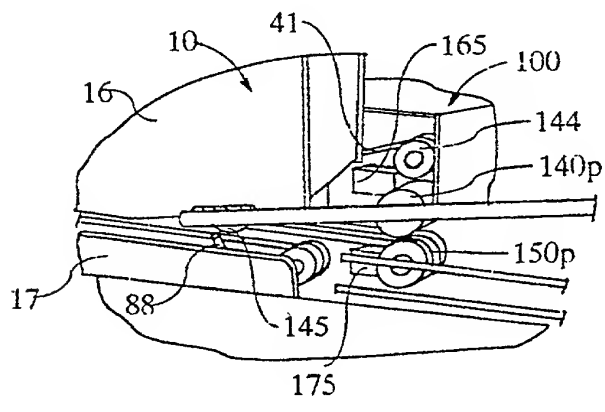


FIG. 3

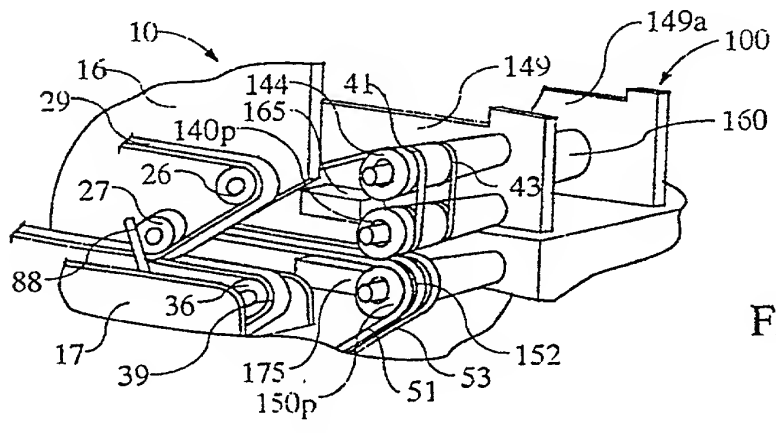


FIG. 4

FIG. 2T 2066200T

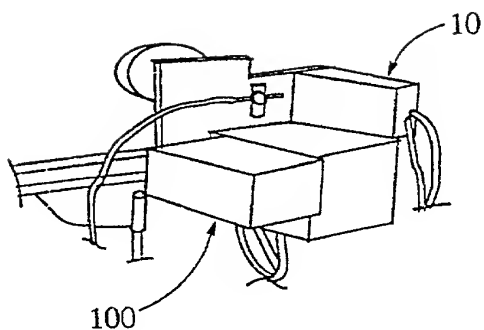


FIG. 5

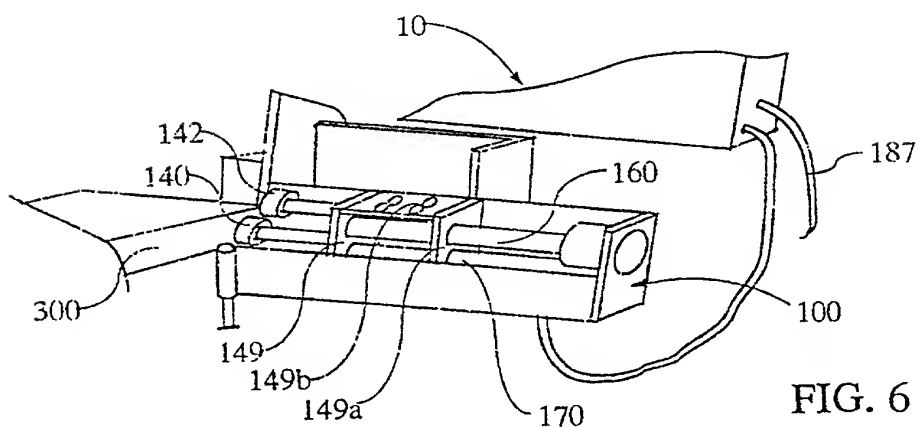


FIG. 6

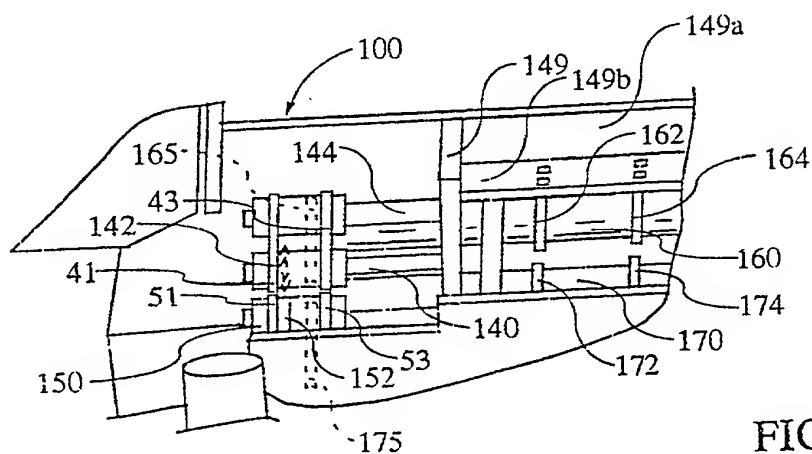


FIG. 7

FIG. 8

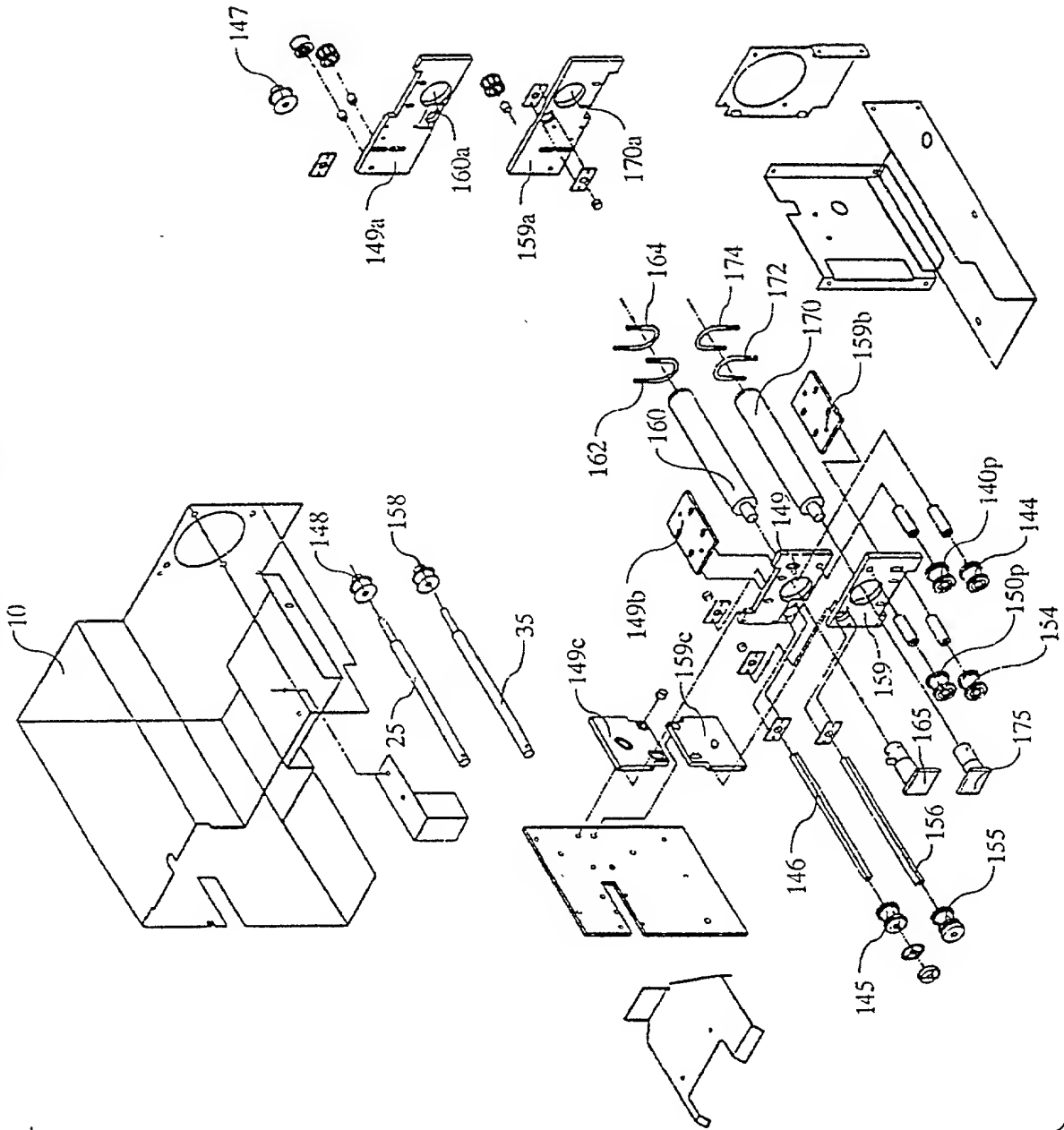


FIG. 8

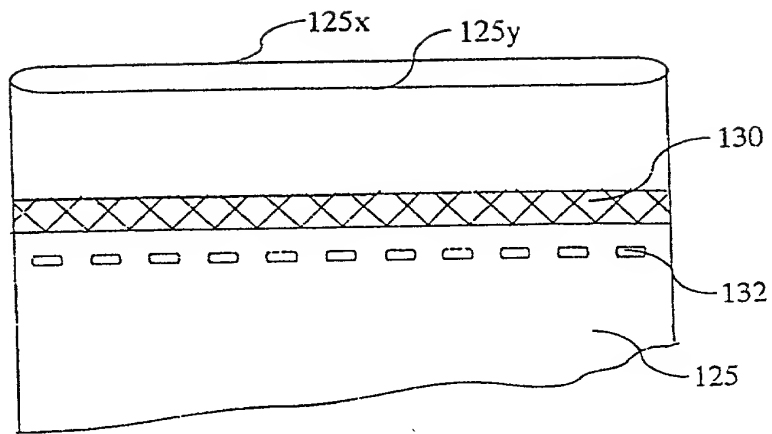


FIG. 9

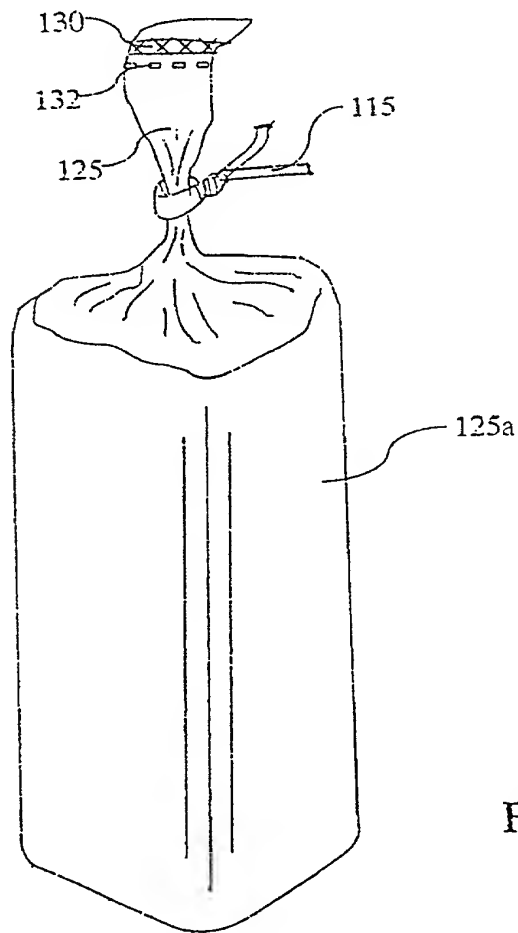


FIG. 10

**BAG SEALING PROFILE FOR PRODUCTION SETUP**

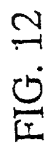
psi equal 25

**MAXIMUM TEMPERATURE 600°F.**

Conveyor Speed FPM	60	50	40	34	28
Servo-tyer FPM	125	104	85	71	56
Servo belt setting	11	10	9	8	7
Bag 2.0 mil	N/A	N/A	600	550	475
Bag 1.5 mil	500	535	500	485	440
Bag 1 mil	550	475	445	415	385

Note: The above temperatures are used as a guide only. Bag characteristics may require temperature adjustment for bag quality.

FIG. 11



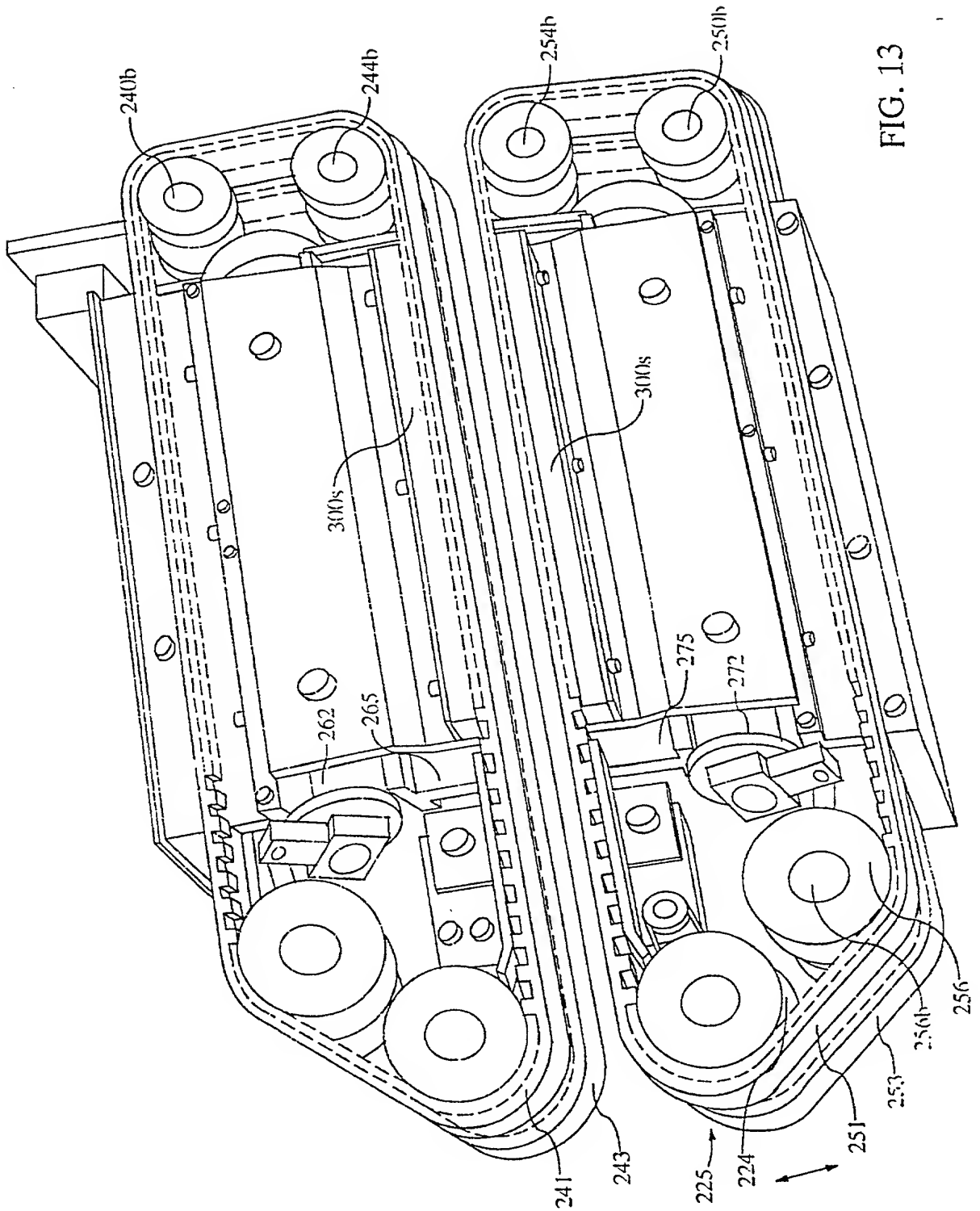
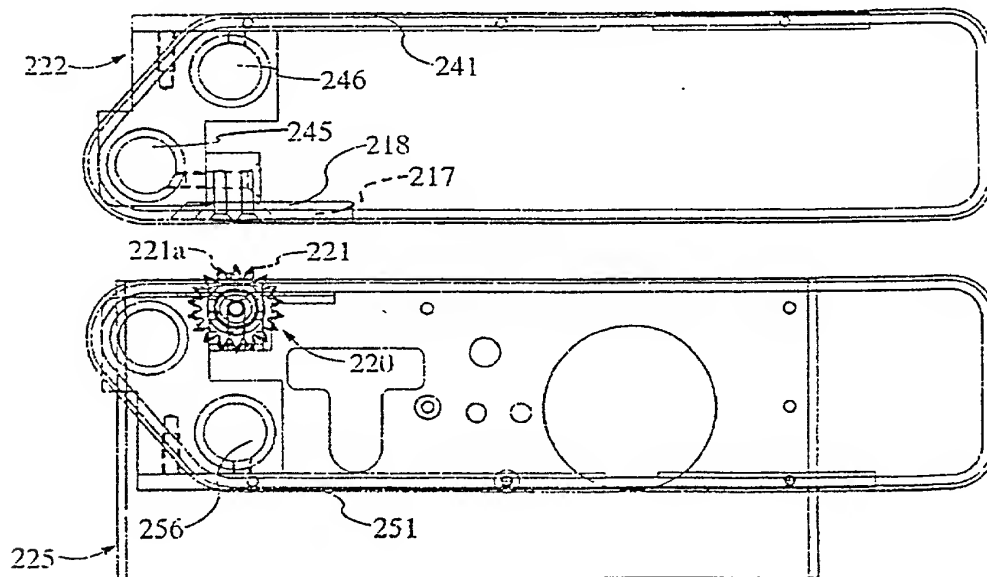
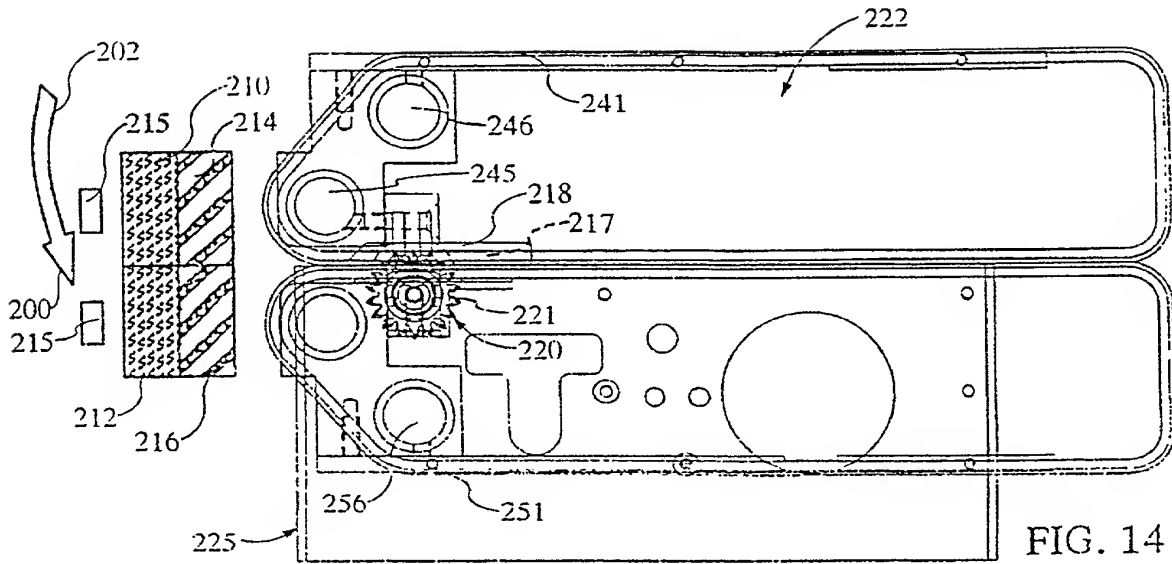


FIG. 13





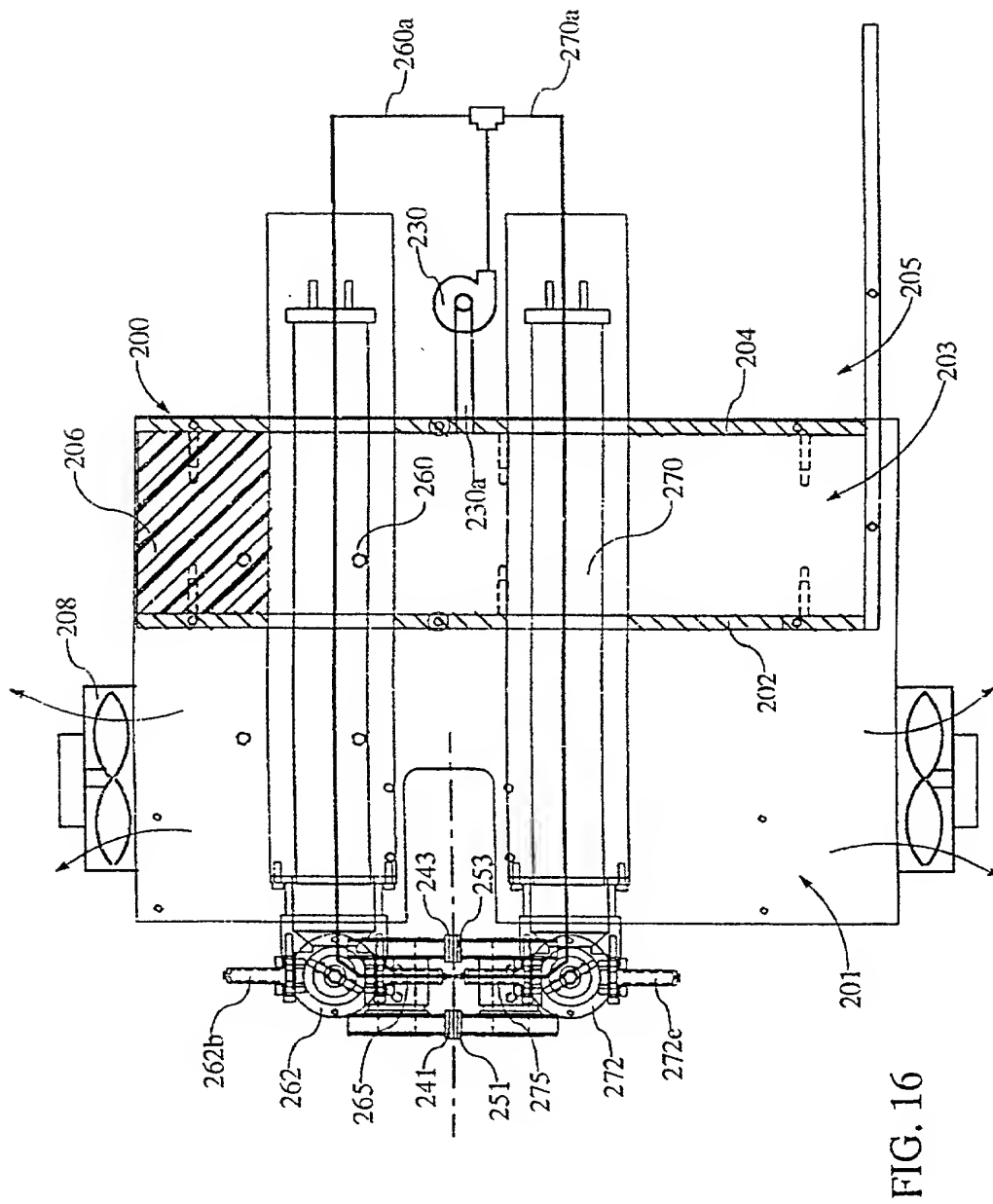


FIG. 16

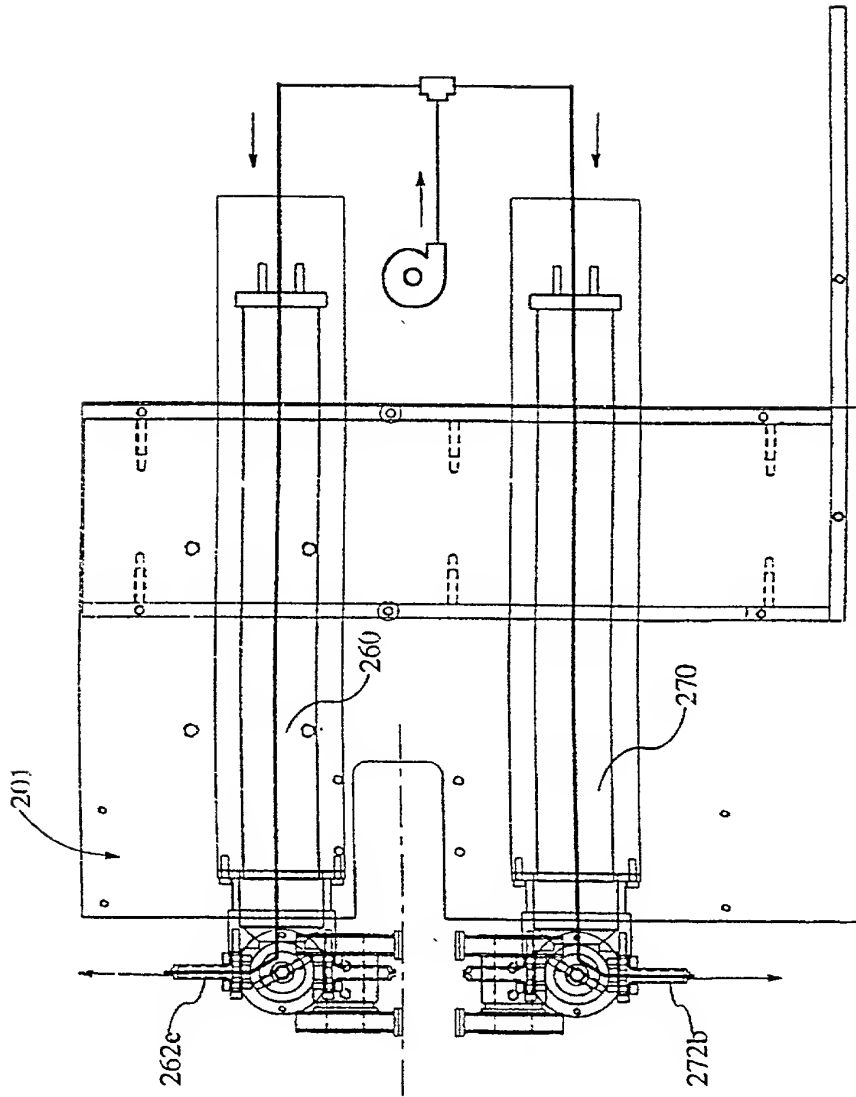


FIG. 17

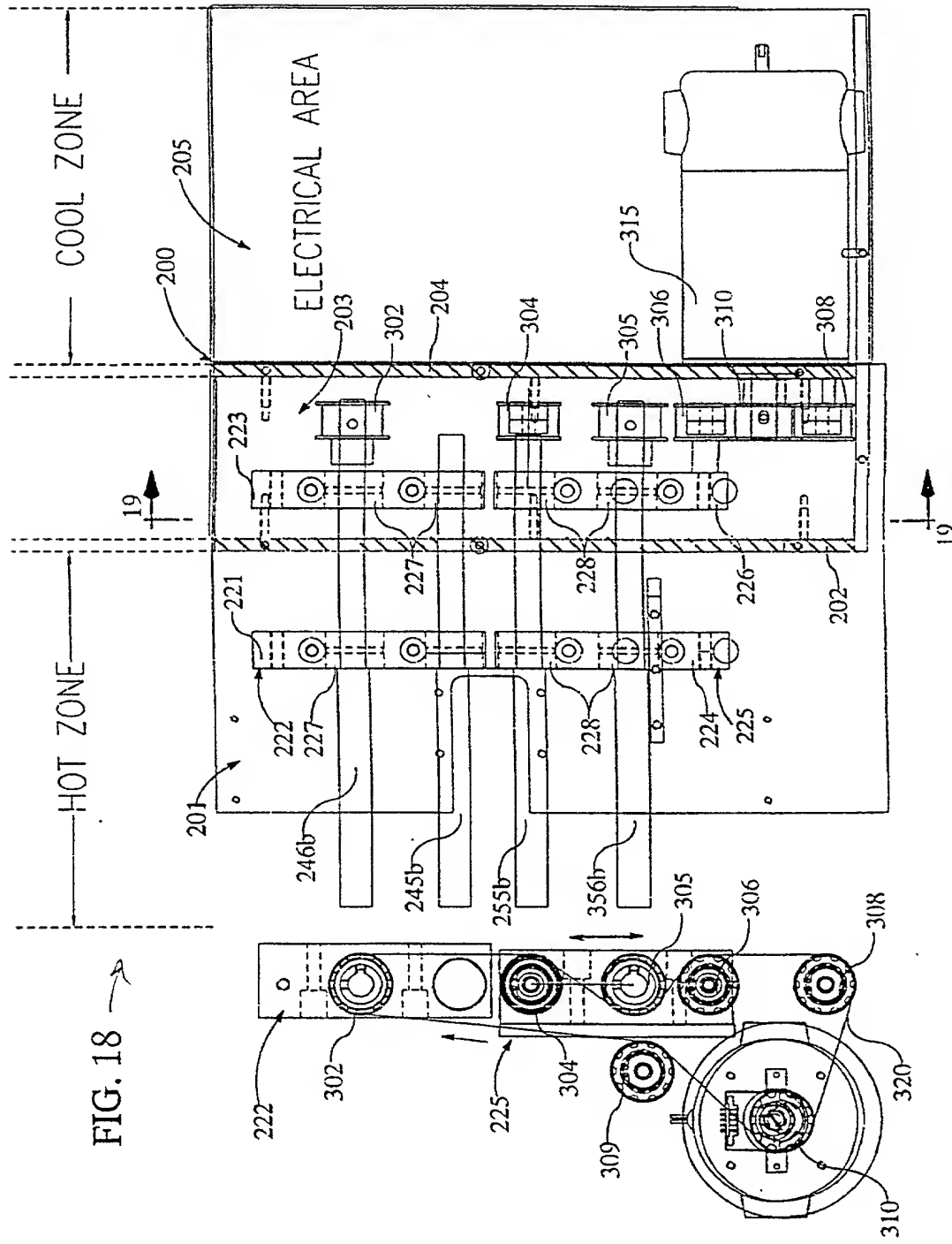
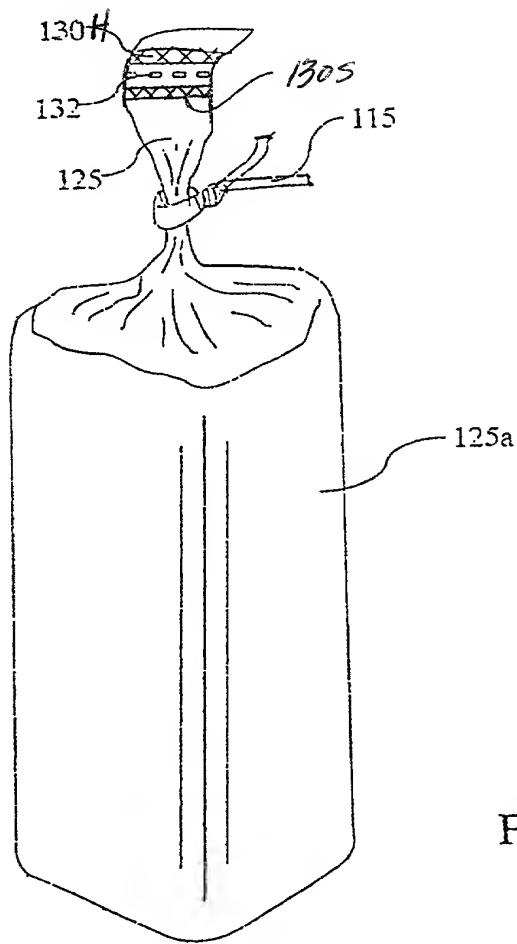
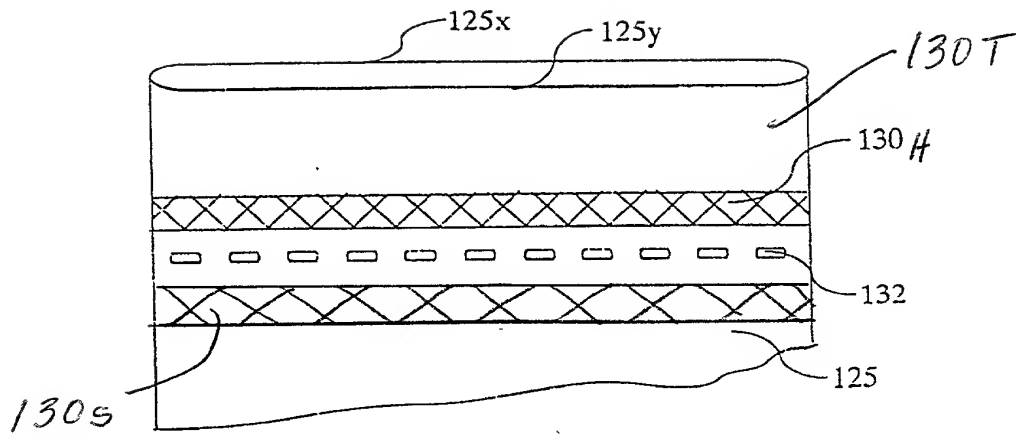


Fig 19



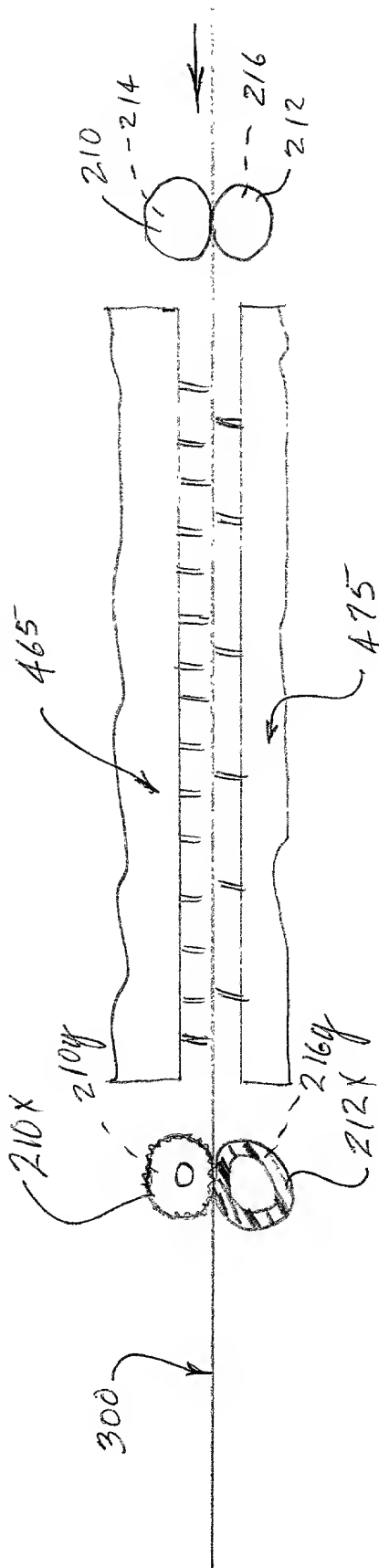


Fig 22

18,4(4)  
(2)

18414  
1  
(3)

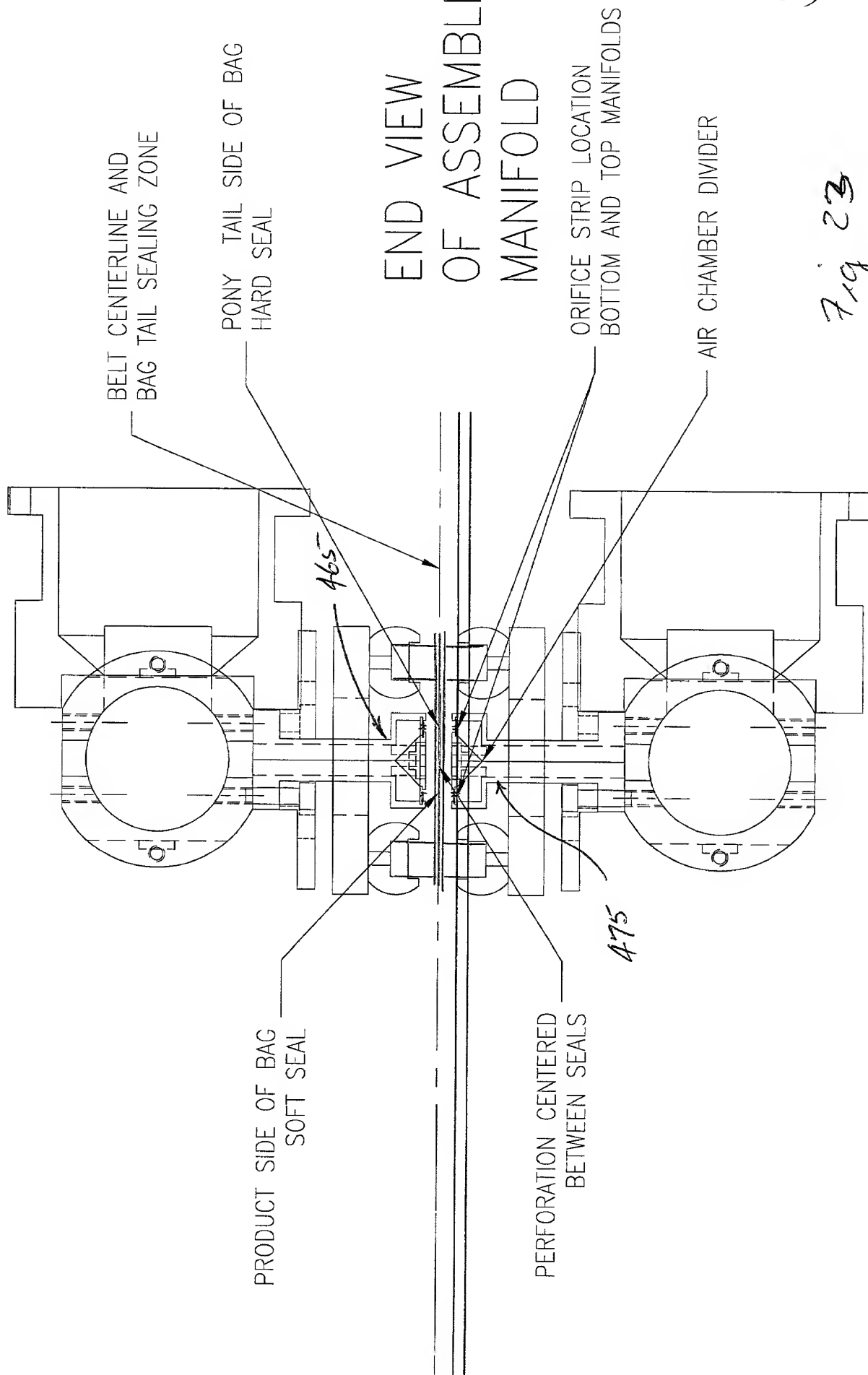
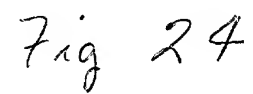


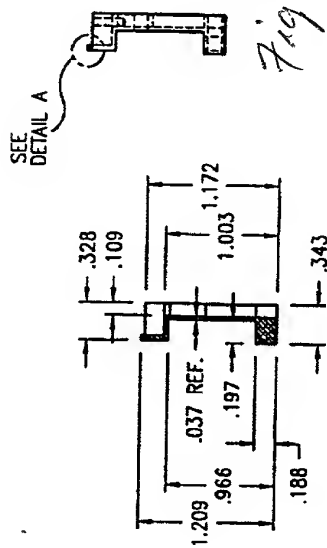
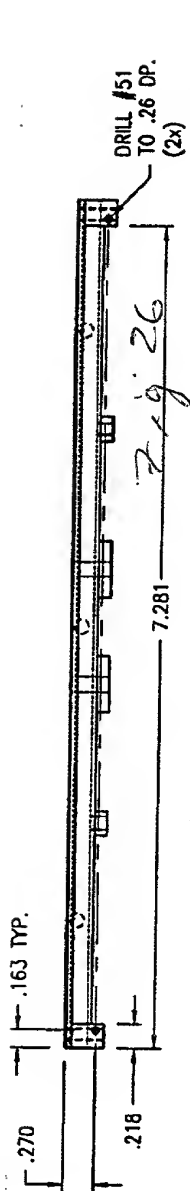
Fig 23

**THE**



18,414-2

TOP VIEW



SECTION A-A  
Fig 28

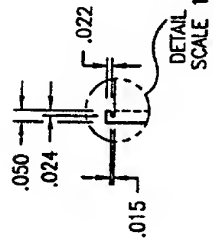


Fig 30

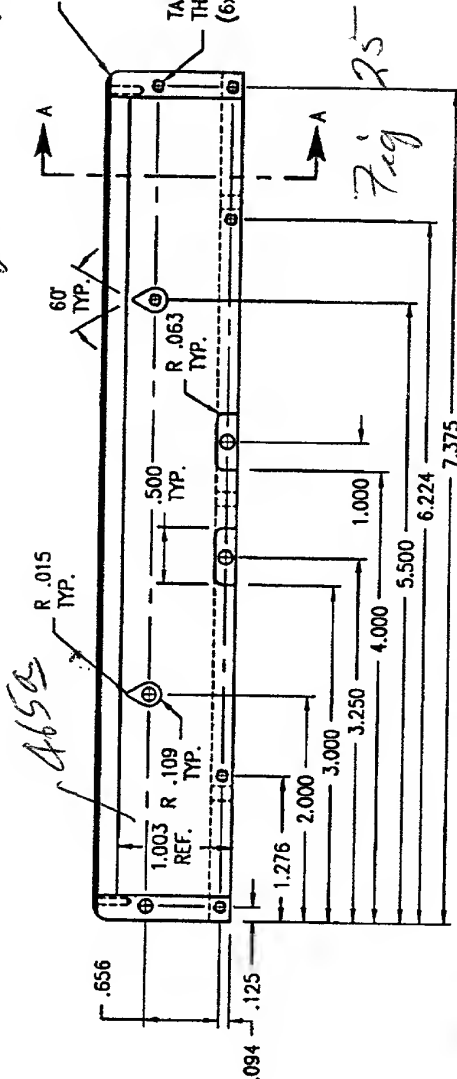


Fig 25

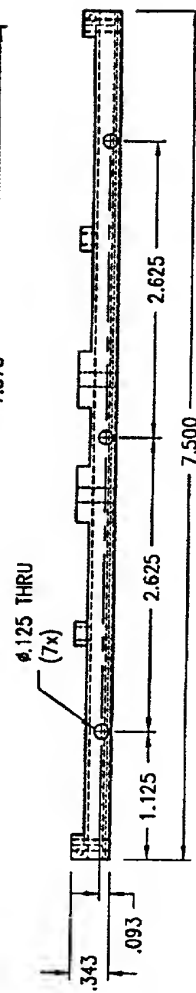


Fig 27

18,414  
(5)



18,414-3

TEST FOOT

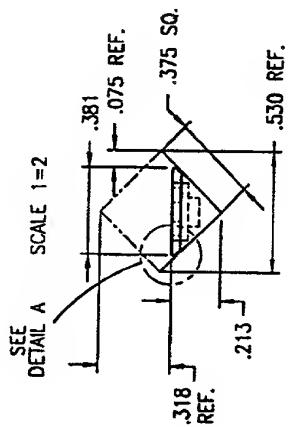
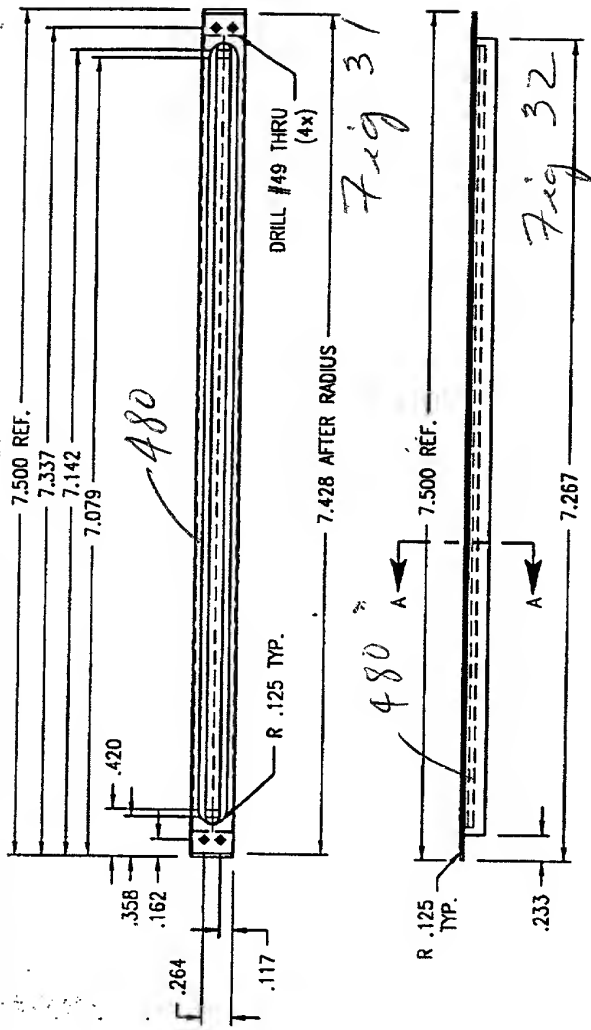
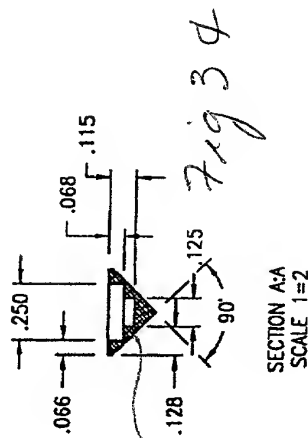


Fig 33



480

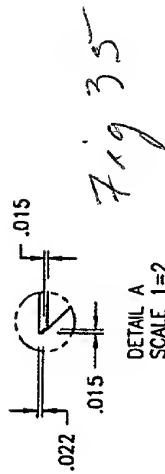
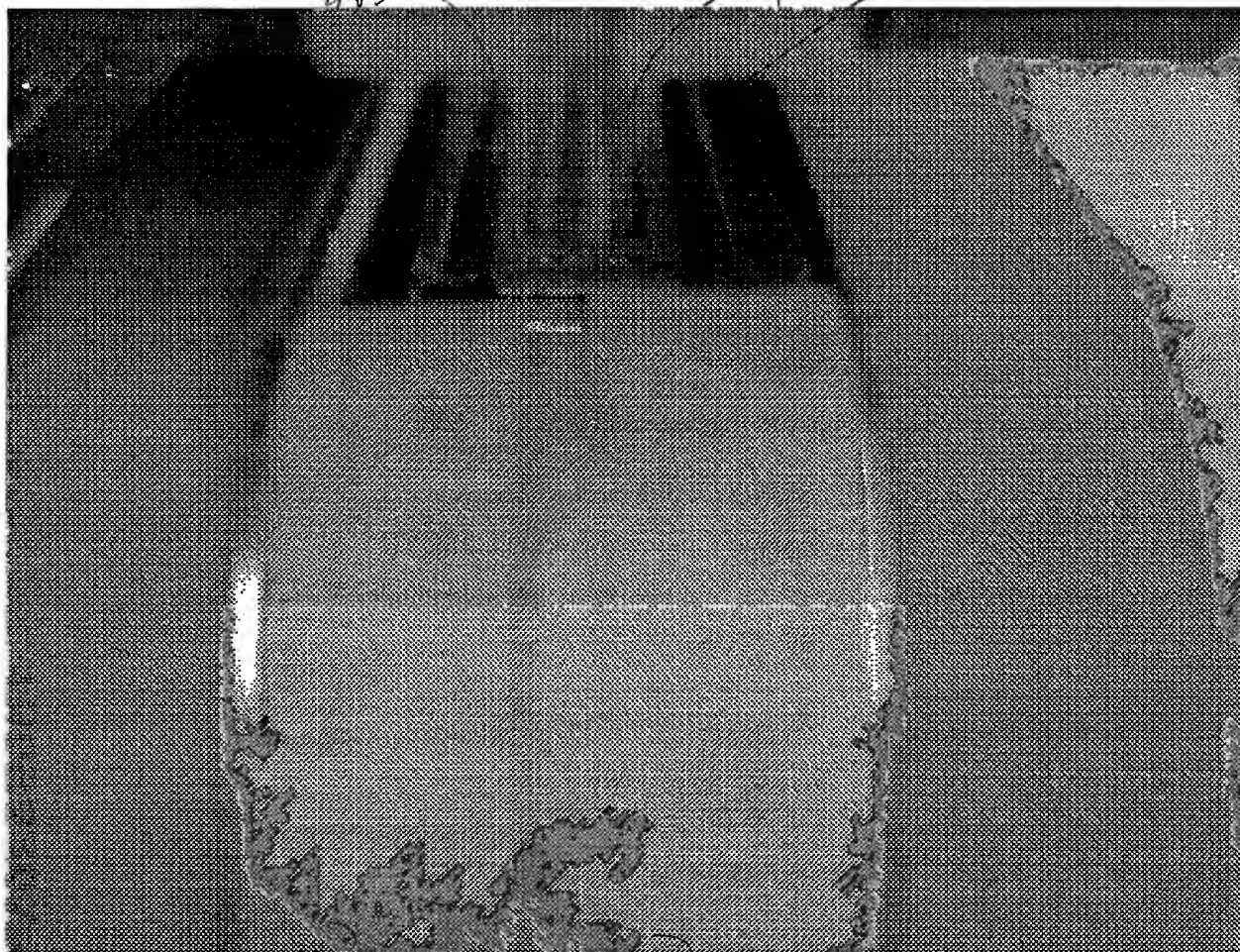


Fig 35

18,414  
(6)



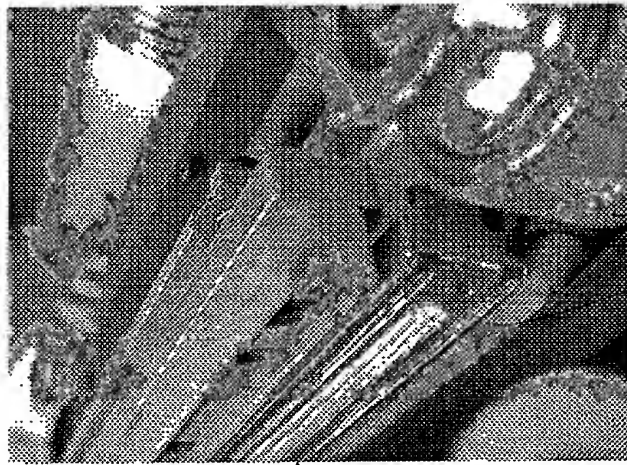
18414  
(7)

212X

216y

Fig 36

121901



18,414  
(8)

Split manifold to separate seal areas

Fig 37

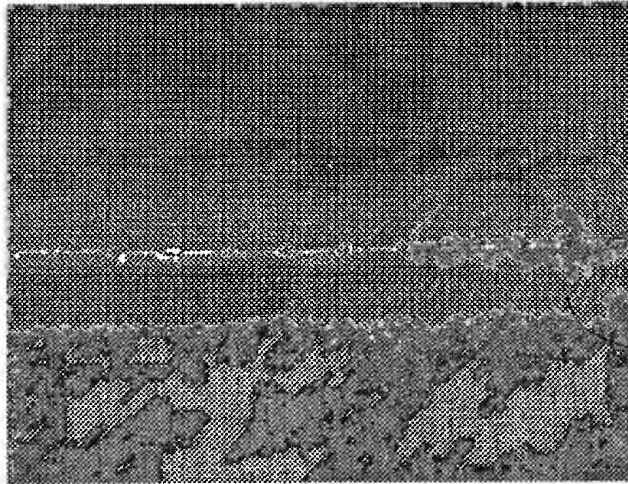


Fig 38

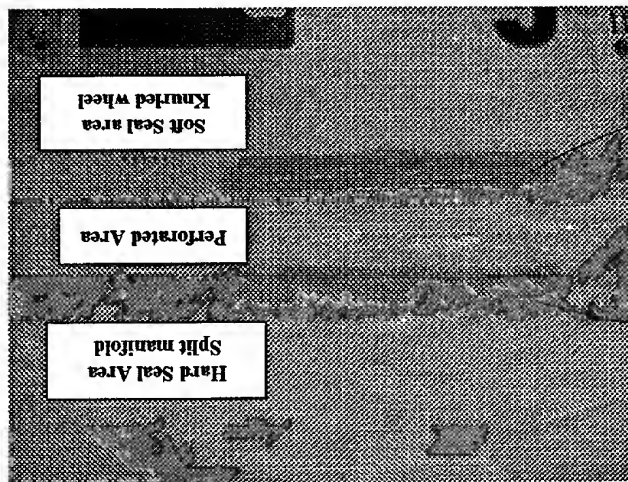


Fig 39

New Design Oshikiri Sealing Unit  
Designed per customer requests